

Work Order ID 72503

Wednesday, July 27, 2011 10:14:34 AM



U/R

Page 1

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID: ~~U/R~~

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date: 11-07-27 Tooling:

Date: _____

Run Start



QC:

Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D212-664-241

Rev ~~B-U/R~~ ECN 11.604

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Blend transition lines only, **do not sand whole tube**:

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

1 Ø
mm.L 11/08/10

110

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

1 Ø
mm.L 11/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72503

Wednesday, July 27, 2011 10:14:34 AM

Page 2

Item ID: D212-664-201TRN

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Revision ID: U/R

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Start Date: 7/27/2011 Start Qty: 1.00

Required Date: 8/16/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

1-Turn second side as per Folio FA114

2-Blend transition lines only, **do not sand whole tube**:

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

3-Remove sand and plugs

4- scribe batch # and part # as per dwg

0.00

0.00

130



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

0.00

mm.L 11/08/10

mm.L 11/08/10

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop



Start Date: 7/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	JPS/DP			1	0	11-8-10	
150 HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion Memo Chemical Conversion Coat as per within 24 hours of machining	0.00 0.00	DP					11-8-11	
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	0	08-11-08/11	

W/O:		WORK ORDER CHANGES					
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Page 4

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00



Packaging

Packaging

Memo

Identify and stock in kanban rack
Location: 2/6

0.00

11-8-11

180

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

CK 11/08/1111-08-11
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, July 27, 2011 10:14:41 AM

Work Order ID: 72503

Parent Item: D212-664-201TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 7/27/2011

Required Date: 8/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6006-129		Manufactured	No			120	Each	20.3000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Crosstube Material

Location

LG

23970

26550

29112

34690

Loc Qty

20.3

.2

.15

0.3

3

Loc Code

9mm.1 11/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 72503
Description: Crosstube Assembly (205/212 High Aft)	Part Number: D212-664-241
Inspection Dwg: D212-664-241 Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.200	✓		vern	JF-01
	R0.063	+/-0.010	.063	✓		RG	
	2.990	+0.005/-0.000	2.994	✓		mic	CNC-04
	5.237	+/-0.030	5.230	✓		vern	JF-01
	2.600	+0.005/-0.000	2.604	✓		mic	CNC-04
	2.686	+0.005/-0.000	2.690	✓		✓	
	2.770	+0.005/-0.000	2.775	✓		✓	
	2.854	+0.005/-0.000	2.857	✓		✓	
	2.938	+0.005/-0.000	2.941	✓		✓	
	3.021	+0.005/-0.000	3.026	✓		mic	CNC-05
	3.133	+0.005/-0.000	3.138	✓		✓	
	3.179	+0.005/-0.000	3.183	✓		✓	
SIDE B	0.200	+/-0.010	.200	✓		vern	JF-01
	R0.063	+/-0.010	.063	✓		RG	
	2.990	+0.005/-0.000	2.994	✓		mic	CNC-04
	5.237	+/-0.030	5.230	✓		vern	JF-01
	2.600	+0.005/-0.000	2.605	✓		mic	CNC-04
	2.686	+0.005/-0.000	2.691	✓		✓	
	2.770	+0.005/-0.000	2.775	✓		✓	
	2.854	+0.005/-0.000	2.855	✓		✓	
	2.938	+0.005/-0.000	2.942	✓		✓	
	3.021	+0.005/-0.000	3.025	✓		mic	CNC-05
	3.133	+0.005/-0.000	3.137	✓		✓	
	3.179	+0.005/-0.000	3.183	✓		✓	
	124.362	+/-0.020	124.360	✓		tape	mm-02

Measured by: mm.l	Audited by: [Signature]	Preliminary Approval: N/A
Date: 11/08/10	Date: 11-8-10	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	

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Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	4	4	MS21920-28	CLAMP (OR MS21920-30)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.362±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-241 = 44.2 lbs (PER IIN-D212-664)
D212-664-241B = 44.2 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING
IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE
OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS
AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE
SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND
MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT
HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72503

2011-07-27

UNDER REVIEW

11.06.13

DEO ATTACHED

RELEASED
2009-10-29

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3; C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-241	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CROSSTUBE ASSY (205/212 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

72503

12 13 15
D2940-1 SUPPORT
MS21920-28 CLAMP, 2X
D3595-063-530 RUBBER CUSHION, 2X
2 PL

14.00 (-241)
OR 13.75 (-241B) D

A5-2 A

A

D212-664-601
BENT TUBE

SYM

D212-664-241/-241B
ASSEMBLY DETAIL D

UNDER REVIEW

UP 11.06.13

DEO ATTACHED

RELEASED
2009-10-28

12
APPLY MAGNOBOND
BETWEEN D2940-1 AND
CROSSTUBE

D2940-1 SUPPORT, REF

13 15
MS21920-28
CLAMP, REF

D3595-063-530 RUBBER CUSHION
UNDER CLAMP, REF

SECTION A-A D6-2
SCALE 4X

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. D
MFG. APPR.	SS	D212-664-241	SHEET 2 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	44	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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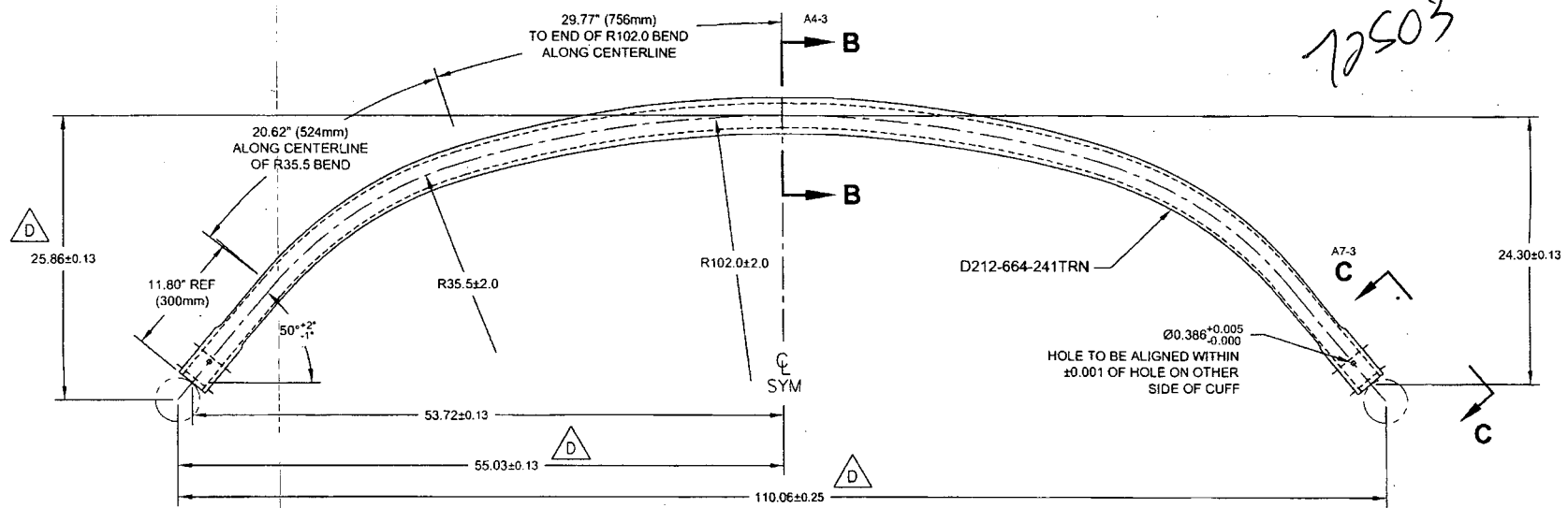
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8 7 6 5 4 3 2 1

12503

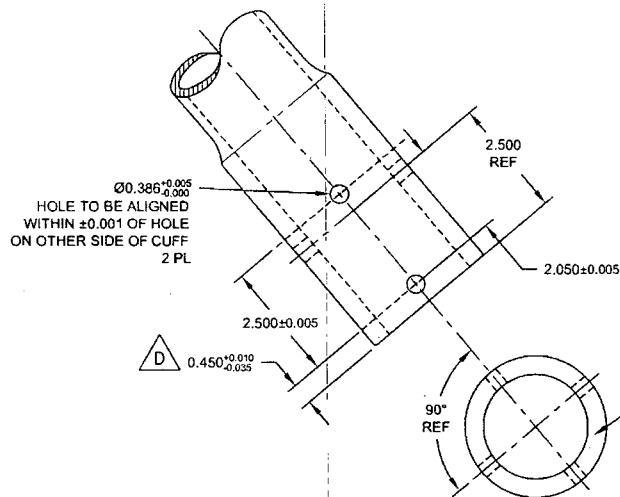


D212-664-601 10 D
BENDING AND DRILLING DETAIL

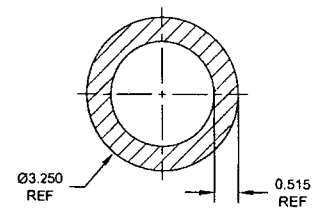
UNDER REVIEW
 11.06.13

DEO ATTACHED

RELEASED
 2009-10-29



VIEW C-C: CUFF DETAIL D2-3
 SCALE 3X



SECTION B-B D4-3
 SCALE 4X

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	9	D212-664-241	SHEET 3 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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8 7 6 5 4 3 2 1

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CHECKED	Q	DRAWING NO.	REV. D
MFG. APPR.	D	D12-664-241	SHEET 4 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	140	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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DRAWING NO. D212-664-241	TITLE CROSSTUBE ASSY (205/212 HI AFT)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-241-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12			

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

77503

RELEASED
2011-04-18
JH

UNDER REVIEW

11.16.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

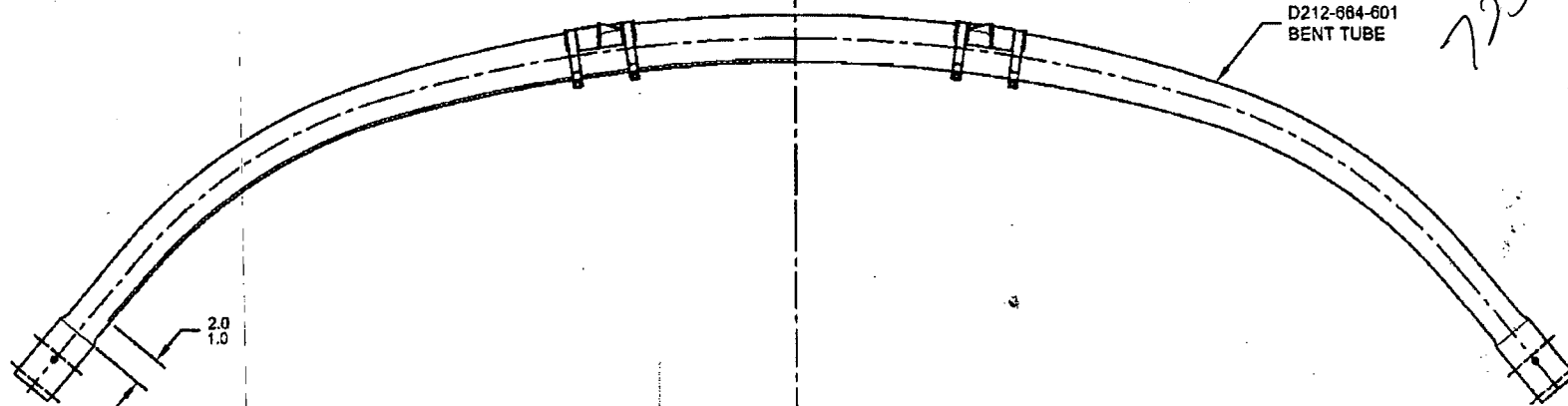
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D212-664-241	TITLE CROSSTUBE ASSY (205/212 HI AFT)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-241-D-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED <i>UP</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>	DE APPR. <i>MD</i>		
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

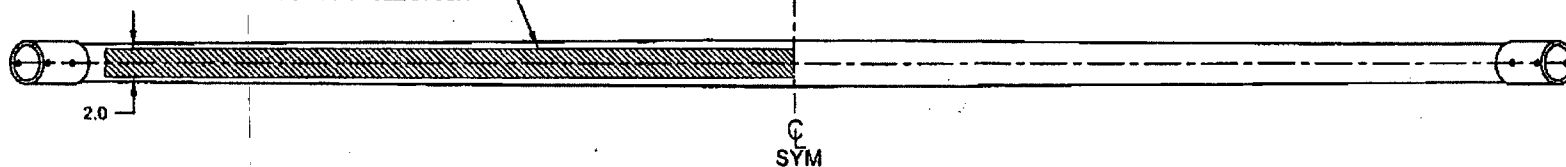
IS:



WAS:

**D212-664-241/-241B
ASSEMBLY DETAIL**

MASK AREA PRIOR TO PAINTING,
REMOVE MASKING AFTER PAINT
AND APPLY CLEAR COAT



RELEASED
2011-04-18
MD

UNDER REVIEW

UP 11.06.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries